

Work Order ID 140647

January 12, 2016 4:21:22 PM

140647

TB ship Jan 20

Page 1

Item ID: D412-702-021

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Shoulder Harness,4 Point Attachment,13 Man Configuration

Start Date: 1/12/2016 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 1/29/2016 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: SH Date: 20160112 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
DSI9559	A
IIN-D412-702-1	A

DAS
6
9-89

MCS 1601-13

DAS
27
9-89

100

Document Control
DOCUMENT CONTROL

0.00

100

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile and create labels per PPP D412-702-021 CHG003

JAN 20 2016

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

DAS
6
9-89

JAN 13 2016

DAS
28
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐				FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
				OTHER : ☐			

Work Order ID 140647

January 12, 2016 4:21:22 PM

140647

Page

Item ID: D412-702-021

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Shoulder Harness,4 Point Attachment,13 Man Configuration

Start Date: 1/12/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 1/29/2016 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC4- 100% Inspect kits for completeness	0.00							
120						DAS 27 9-89			
QC	Memo	0.00				JAN 20 2016			
Quality Control									
130	Packaging	0.00							
130						DAS 27 9-89			
Packaging	Memo	0.00				JAN 20 2016			
Packaging	Identify and pack for shipping as per PPP D412-702-021 Location: <u>629</u>								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00				MCS		JAN 20 2016	
Quality Control									

MCS JAN 20 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

Picklist Print

Janudry 12, 2016 4:21:26 PM

Page 1

Work Order ID: 140647

140647

Parent Item: D412-702-021

D412-702-021

Parent Item Name: Shoulder Harness,4 Point Attachment,13 Man Configuration

Start Date: 1/12/2016

Required Date: 1/29/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:B Removed Manufacturing 05-11-08 JLM
 IPP Rev:C06.04.03As per DSI9324 JLM
 IPP rev D 06.12.14 per ecn 871 EC
 IPP Rev:E 07-03-14 As per DSI 9351 JLM
 IPP Rev:F 07-07-28 As per Rev E JLM Verified By:ec IPP Rev.G
 11.05.31 DSI 9559 EC verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN4-13A		Purchased	No			120	Each	148.0000	4	4		DAS 6 9-89	
AN4-13A									**				DAS 28 9-89
Bolt													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				FG				20					
				122808				20					
				ST344				128					
				m133769				128					
AN4-20A		Purchased	No			120	Each	148.0000	8	8			
AN4-20A									**				
Bolt													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				GA				24					
				m116419				24					
				ST343				124					
				m132680				74					
				m133694				50					

DAS 6 9-89 DAS 28 9-89
 JAN 18 2016

Picklist Print

Janudry 12, 2016 4:21:27 PM

Page 2

Work Order ID: 140647

140647

Parent Item: D412-702-021

D412-702-021

Parent Item Name: Shoulder Harness,4 Point Attachment,13 Man Configuration

Start Date: 1/12/2016

Required Date: 1/29/2016

Start Qty: 1.00

Required Qty: 1.00

AN4-5A

Purchased

No

120

Each

107.0000

4

4

AN4-5A

BOLT

DAS
27
9-89

Location

Loc Qty

Loc Code

DAS
6
9-89

DAS
28
9-89

CA

55

m129682

55

over003

50

m133064

50

ST345

2

m132317

2

D3195-041

Manufactured

No

120

Each

4.0000

2

2

D3195-041

Bracket

DAS
6
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

ST021

4

135729

4

D3195-043

Manufactured

No

120

Each

5.0000

2

2

D3195-043

Bracket

DAS
6
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

ST021

5

135730

5

D3196-1

Manufactured

No

120

Each

4.0000

1

1

D3196-1

Bar

DAS
6
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

ST256

4

135581

4

DAS
27
9-89

JAN 13 2016

January 12, 2016 4:21:27 PM

Shop Packet Print

Page 2

Picklist Print

January 12, 2016 4:21:27 PM

Page 3

Work Order ID: 140647

140647

Parent Item: D412-702-021

D412-702-021

Parent Item Name: Shoulder Harness, 4 Point Attachment, 13 Man Configuration

Start Date: 1/12/2016

Required Date: 1/29/2016

Start Qty: 1.00

Required Qty: 1.00

D3196-3 Manufactured No

120

Each

1.0000

1

1

D3196-3

Bar

**

DAS

6

DAS

9-89

28

9-89

Location

Loc Qty

Loc Code

ST256

1

118832

1

120

Each

0.0000

1

1

D3196-4 Manufactured No

D3196-4

Bar

**

DAS

6

DAS

9-89

28

9-89

Location

Loc Qty

Loc Code

ST256

3

135642

2

137480

1

120

Each

6.0000

4

4

D3198-1 Manufactured No

D3198-1

Fitting

**

DAS

6

DAS

9-89

28

9-89

Location

Loc Qty

Loc Code

ST021

6

136514

6

D3268-1 Manufactured No

D3268-1

Placard

**

DAS

6

DAS

9-89

28

9-89

Location

Loc Qty

Loc Code

ST028

9

135643

9

JAN 13 2016

January 12, 2016 4:21:27 PM

Shop Packet Print

Page 3

Picklist Print

January 12, 2016 4:21:27 PM

Page 4

Work Order ID: 140647

140647

Parent Item: D412-702-021

D412-702-021

Parent Item Name: Shoulder Harness,4 Point Attachment,13 Man Configuration

Start Date: 1/12/2016

Required Date: 1/29/2016

Start Qty: 1.00

Required Qty: 1.00

D3546-1

Manufactured No

120 Each

20.0000

2

2

D3546-1

Clip

DAS
27
9-89

Location

Loc Qty

Loc Code

ST042

10

118984

10

ST051A

10

127598

10

**

DAS

6

9-89

DAS

28

9-89

D3551-11

Manufactured No

120 Each

22.0000

13

13

D3551-11

Hook And Loop Tie

DAS
27
9-89

Location

Loc Qty

Loc Code

ST416

22

135736

22

**

DAS

6

9-89

DAS

28

9-89

D412-702-069

Manufactured No

120 Each

6.0000

1

1

D412-702-069

Grommet

DAS
27
9-89

Location

Loc Qty

Loc Code

PKg015a

6

121269

6

**

DAS

6

9-89

DAS

28

9-89

D4387-041

Manufactured No

120 Each

14.0000

9

9

D4387-041

Harness Assy

DAS
27
9-89

Location

Loc Qty

Loc Code

ST467

14

135637

14

**

DAS

6

9-89

DAS

28

9-89

JAN 13 2016

January 12, 2016 4:21:27 PM

Shop Packet Print

Page 4

Picklist Print

January 12, 2016 4:21:27 PM

Page 5

Work Order ID: 140647

140647

Parent Item: D412-702-021

D412-702-021

Parent Item Name: Shoulder Harness,4 Point Attachment,13 Man Configuration

Start Date: 1/12/2016

Required Date: 1/29/2016

Start Qty: 1.00

Required Qty: 1.00

D4387-043

Manufactured No

120

Each

12.0000

4

4

D4387-043

Harness Assembly

DAS
27
9-89

Location

Loc Qty

Loc Code

ST465

12

134372

3

134774

4

135945

5

DAS
6
DAS
28
9-89

MS21042L4

Purchased

No

120

Each

2,578.000

12

12

MS21042L 4

Locknut

DAS
27
9-89

Location

Loc Qty

Loc Code

FP001

41

m133363

41

GA

26

m127813

26

ST303

2414

m133769

2414

ST305

97

m130922

97

DAS
28
9-89

MS24694-S152

Purchased

No

120

Each

38.0000

8

8

MS24694-S152

Screw

DAS
27
9-89

Location

Loc Qty

Loc Code

ST282

38

m133011

38

DAS
6
9-89

DAS
28
9-89

January 12, 2016 4:21:27 PM

Shop Packet Print

Page 5

Picklist Print

January 12, 2016 4:21:27 PM

Page 6

Work Order ID: 140647

140647

Parent Item: D412-702-021

D412-702-021

Parent Item Name: Shoulder Harness,4 Point Attachment,13 Man Configuration

Start Date: 1/12/2016

Required Date: 1/29/2016

Start Qty: 1.00

Required Qty: 1.00

MS24694-S154

Purchased

No

120

Each

23.0000

8

8

MS24694-S154

Screw

DAS
27
9-89

Location

Loc Qty

Loc Code

ST282

23

m131618

3

m133134

20

NAS1149D0463J

Purchased

No

120

Each

2,751.000

20

20

NAS1149D0463.J

WASHER

DAS
27
9-89

Location

Loc Qty

Loc Code

GA

397

M129390

41

M132035

356

ST260a

500

M133932

500

ST263

430

M133284

32

M133316

398

ST269

1424

M129682

39

M130799

361

M132317

101

M132677

888

M133077

35

DAS
6
DAS
28
9-89

JAN 13 2016

20160112 SH
140647

DART SERVICE INSTRUCTION

TO AMEND IIN-D412-702-1 REV. A,
AND ICA-D412-702 REV. 4 OR EARLIER APPROVED REVISIONS
REF. TCCA STC: SH04-7
REF. FAA STC: SR01997NY
REF. EASA STC: EASA.IM.R.S.00710

PURPOSE

The purpose of this DSI is to outline the replacement of existing D3446-041/-043 Shoulder Harnesses with the new and improved D4387-041/-043 Shoulder Harnesses.

CHANGE

For the following Kits, the D4387-041 and D4387-043 Shoulder Harnesses respectively replace the D3446-041 and D3446-043 Shoulder Harnesses as follows:

Old Harness P/N	Used On	New Harness P/N	Effectivity
D3446-041	D412-702-021	D4387-041	CHG 003 and subsequent
	D412-702-023		
	D412-702-027		CHG 002 and subsequent
	D412-702-029		
D3446-043	D412-702-021	D4387-043	CHG 003 and subsequent
	D412-702-025		CHG 002 and subsequent

Customers who want to upgrade their shoulder harnesses may replace their existing D3446-041/-043 with D4387-041/-043 per this service instruction.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 11.05.09
CERT. NO.: SH04-7
ISSUE NO.: 3

A	NEW ISSUE	MB	11.05.09	
REV.	DESCRIPTION	BY	DATE	
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN				
CHECKED		DRAWING NO.	DSI 9559	REV. A
MFG. APPR.	N/A	SHEET 1 OF 1		
APPROVED		TITLE	HARNESS CHANGE	
DE APPR.		SCALE	NTS	
DATE	11.05.09	COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		

QTY -021	QTY -023	QTY -025	QTY -027	QTY -029	QTY -035	Part Number	Description
X						D412-702-021	Dart 13-Man Shoulder Harness Kit, 4-point
	X					D412-702-023	Dart 5-Man Forward Facing Shoulder Harness Kit, 4-point
		X				D412-702-025	Dart 4-Man Aft Facing Shoulder Harness Kit, 4-point
			X			D412-702-027	Dart 4-Man Side Facing Shoulder Harness Kit, 4-point
				X		D412-702-029	Dart 1-Man Forward Facing Shoulder Harness Kit, 4-point
					X	D214-702-035	Dart 5-Man Aft Facing Shoulder Harness Kit, 4-point, for Bell 214B/B-1
1	1		1	1		D412-702-069	GROMMET KIT
2	2					D3195-041	BRACKET
2	2					D3195-043	BRACKET
1	1			1		D3196-1	BAR
1			1			D3196-3	BAR
1			1			D3196-4	BAR
2	2					D3197-041	BAR
4		4				D3198-1	FITTING
2	2					D3268-1	PLACARD
9	5		4	1		D3446-041	HARNESS ASSEMBLY, 4 POINT
4		4				D3446-043	HARNESS ASSEMBLY, 4 POINT
					5	D3446-045	HARNESS ASSEMBLY, 4 POINT
13	5	4	4	1	5	D3551-11	HOOK AND LOOP TIE
2	2					D3546-1	CLIP
4		4				AN4-5A	BOLT
4	4					AN4-13A	BOLT
8		8				AN4-20A	BOLT
20		20				AN960JD416	WASHER (OR NAS1149D0463J)
12		12				MS21042L4	NUT (OR MS21042-4)
8	2		6	2		MS24694-S152	SCREW
8	2		6	2		MS24694-S154	SCREW

QTY -069	Part Number	Description
X	D412-702-069	GROMMET KIT
24	D3619-2	GROMMET
1	D3619-2T1	HOLE PUNCH
1	D3619-2T2	STRIKER BLOCK
1	D3619-2T3	PUNCH
1	D3619-2T4	DIE

REFERENCE ONLY

DART SERVICE INSTRUCTION

TO AMEND IIN-D412-702-1 REV. A,
AND ICA-D412-702 REV. 4 OR EARLIER APPROVED REVISIONS

REF. TCCA STC: SH04-7
REF. FAA STC: SR01997NY
REF. EASA STC: EASA.IM.R.S.00710

PURPOSE

The purpose of this DSI is to outline the replacement of existing D3446-041/-043 Shoulder Harnesses with the new and improved D4387-041/-043 Shoulder Harnesses.

CHANGE

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Old Harness P/N	Used On	New Harness P/N	Effectivity
D3446-041	D412-702-021	D4387-041	CHG 003 and subsequent
	D412-702-023		CHG 002 and subsequent
	D412-702-027		CHG 002 and subsequent
	D412-702-029		CHG 002 and subsequent
D3446-043	D412-702-021	D4387-043	CHG 003 and subsequent
	D412-702-025		CHG 002 and subsequent

Customers who want to upgrade their shoulder harnesses may replace their existing D3446-041/-043 with D4387-041/-043 per this service instruction.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 11.05.09
CERT. NO.: SH04-7
ISSUE NO.: 3

A	NEW ISSUE	MB	11.05.09
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9559	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		HARNES CHANGE	NTS
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